

Work Order ID 154938

Tuesday, January 03, 2017 5:08:27 PM

154938

Page 1

Item ID: D2530

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Handle Weldment

Start Date: 1/9/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/16/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

Date:

JAN 04 2017

Tooling:

Date:

QC:

9-89

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2530	Rev B ✓								
100	Small Fab	0.00							
100									
Small Fab	Memo	0.14							
Small Fab	1-Cut to length as per Dwg D2536 2-Deburr								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Weld per dwg A/R S.S. rod Batch: M134442	0.00							
120	Small Fab								
Large Fab	Memo	0.13							
Large Fab	1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301								

4 0 17-1-16 DAS 19 9-89

DAS 38 9-89

4 17-3-13 JAN 16 2017



Work Order update only

Work Order: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐							
Part No. _____				Date :		Step #:		QTY Effective :		MRB (QSI042) Approval	
NCR No. _____				Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Temperature/Cure ☐ Bending ☐ Set-up ☐ Centre Not Concentric ☐ BOM/Route ☐ Cracks ☐ Broken/Damage/Defect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Cuffs ☐ Contamination ☐ Crushing ☐ Countersink ☐ Heat Treat ☐ Cut Too Short ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Marks/Chatter ☐ Drill Holes ☐		FAULT CATEGORY Power Loss/Surge ☐ Positioned Wrong ☐ Folio/Program ☐ Outside Dimensions ☐ Grain ☐ Over/Under tolerance ☐ Weld ☐ Part Incorrect ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Out of Sequence ☐ Part Moved ☐ Off-set ☐ Drawing ☐ Mislabeled ☐ Finish ☐ Fit/Function ☐ Misread ☐ Misaligned/off center ☐ Turning Sequence ☐							
		OTHER :									

Work Order ID 154938***154938***

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Item ID: D2530 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Handle Weldment
Start Date: 1/9/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/16/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
130									
QC	Memo	0.00				(4)	17.03.14		DAS 9 9-89
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.01				(4)	17.03.14		DAS 9 9-89
Quality Control									
150	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
150	M 136370.								
Powdercoat	Memo	0.01							
Powder Coating	START TIME: 8:55								
	OVEN TEMPERATURE: 300°								
	FINISH TIME: 9:25								
						4	17.03.20		334 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause		FAULT CATEGORY																							
Environment ☐		No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																			
Design ☐		Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																			
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						4			DAS 38 9-88
QC	Memo	0.01							MAR 20 2017
Quality Control									
170	Identify as per dwg & Stock Location: ST379	0.00							
170						4			
Packaging	Memo	0.01							MAR 20 2017
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.07							17/3/21
Quality Control									

DAS
21
9-88
MAR 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

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Page 1

Work Order ID: 154938

154938

Parent Item: D2530

D2530

Parent Item Name: Handle Weldment

Start Date: 1/9/2017

Required Date: 1/16/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F
11.01.07 chg qc 5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2534		Manufactured	No			120	Each	21.0000	2	8			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2534

Lock Plate

**

12/17-3/13

15883818 Location

Loc Qty

Loc Code

WA004

21

145921

20

152297

1

M304TR0.750W.049

Purchased

No

100

f

132.9117

2.9145

12.27158

M304TR0 750W 049

304 RD Tube .750 x .049W

**

17-1-16

DAS
19
9-89

Location

Loc Qty

Loc Code

GA002

132.9117491

M134528

30.2105266

M134604

4.41368

M134824

4.8478935

M135093

12.016315

x2 M135242

32.1852715

x3 M135373

39.983907

M135709

0.0790537

M135857

0.0003668

M136323

9.174735

6.13579

6.13579

DQA: _____ Date: _____



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